

Dart Aerospace Ltd.

Process Sheet

51

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Photocopy bluefile & create labels per PPP D412-630-034 CHG003

2.0	D2012107	Clevis
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Clevis

Pick:

Qtv

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

Batch
B33 585

 mf

3.0	D2803042	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
Bracket Assembly

Pick:

Q_{tv}

Qty	Part Number	Description
1	D2803-042	Bracket Assembly RH

Batch

Batch
B29392 (73)

mf

40	D2804042	Bracket Assembly
----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
Bracket Assembly

Pick:

Qtv

Qty	Part Number	Description
1	D2804-042	Bracket Assembly RH

Batch

Batch
B290409

mf

07-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/16/2007 11:52:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35798

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

D2807041

GAS SPRING ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Support Prop

Batch: B35962

(x6)

mf

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

2

D2813

Washer

B32776

(x6)

mf

7.0

D3562042

STEP ASSEMBLY, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Step Weldment LH

Pick:

Qty

Part Number

Description

Batch

1

D3562-042

Step Weldment RH

B35263

(x3)

mf

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Bushing

Pick:

Qty

Part Number

Description

Batch

4

D3395-1

Bushing

B32783

(x12)

mf

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

BOLT

Pick:

Qty

Part Number

Description

Batch

2

AN3C21A

Bolt

B1101189

(x6)

mf

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick:

~~B1105545~~

(x6)

B1102736

mf 07-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35798

Part Number: D412630034

Job Number:



Seq. #: Machine Or Operation: Description :

Qty	Part Number	Description	Batch
2	AN8C16	Bolt	

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	AN310C8	Nut	M104679 (t6)

mf

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description	Batch
2	MS24665-302	Cotter Pin (or AN380C3-4)	M16941 (t6)

mf

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
6	NAS1515H3	Washer	M105164 (t18)

mf

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H5L	Washer	M105728 (t12)

mf

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H8	Washer	M104611 (t12)

mf

07-11-28 (t3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Friday, 11/16/2007 11:52:49 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35798

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description:

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M105728 (x10)

mk

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390 (x6)

mk

07/04/27

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: m104929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: m17045

mk 07-11-28 (x3)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/29 (x3)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description

Batch

B33590

07/11/29 (x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Friday, 11/16/2007 11:52:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35798

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

2

D2806-1

Bushing

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number

2 D2806-3

Description

Bushing

Batch

B29847

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number

1 D2810-5

Description

Strut

Batch

B32775

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number

2 D3396-1

Description

Spacer

Batch

B29496

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

1 AN4C6A

Description

Bolt

Batch

M105426

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

1 AN4C10A

Description

Bolt

Batch

M101189

7/11/29 (83)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/16/2007 11:52:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35798

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	M103915

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN44-C7A	Eyebolt	M101711

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	M101291

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M104715

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	M105792

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 09/11/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/16/2007 11:52:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP RH (FOLDING)

Job Number: 35798

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M105293

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

M105930

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

A

7/14/30 (3)

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 8/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35798

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Revision: L
Date: 07.09.30

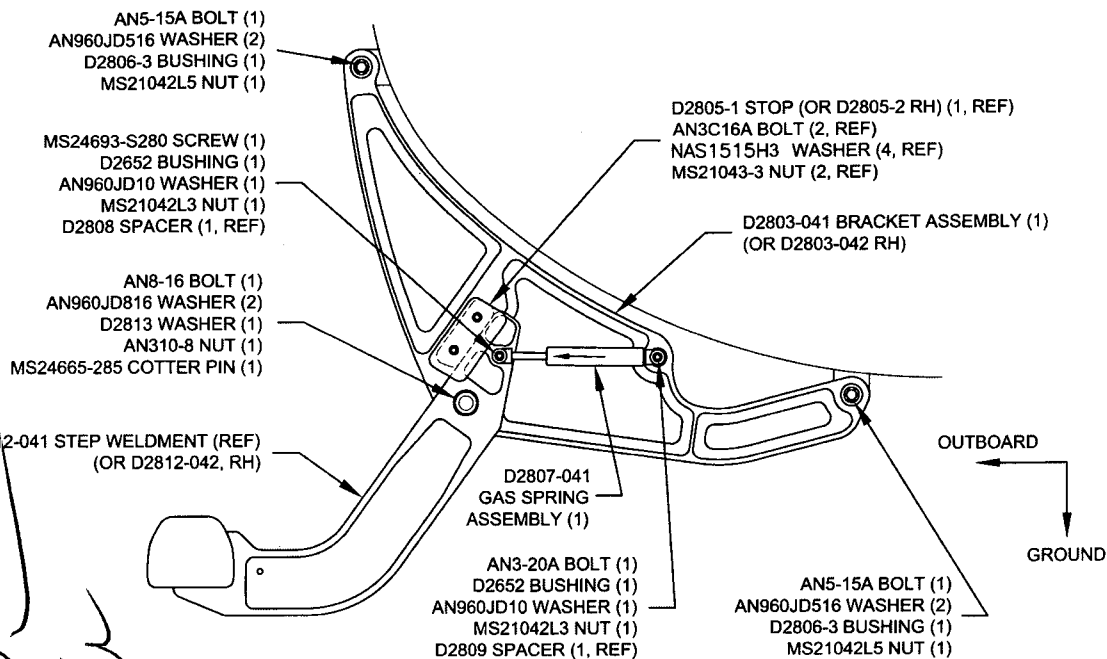
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

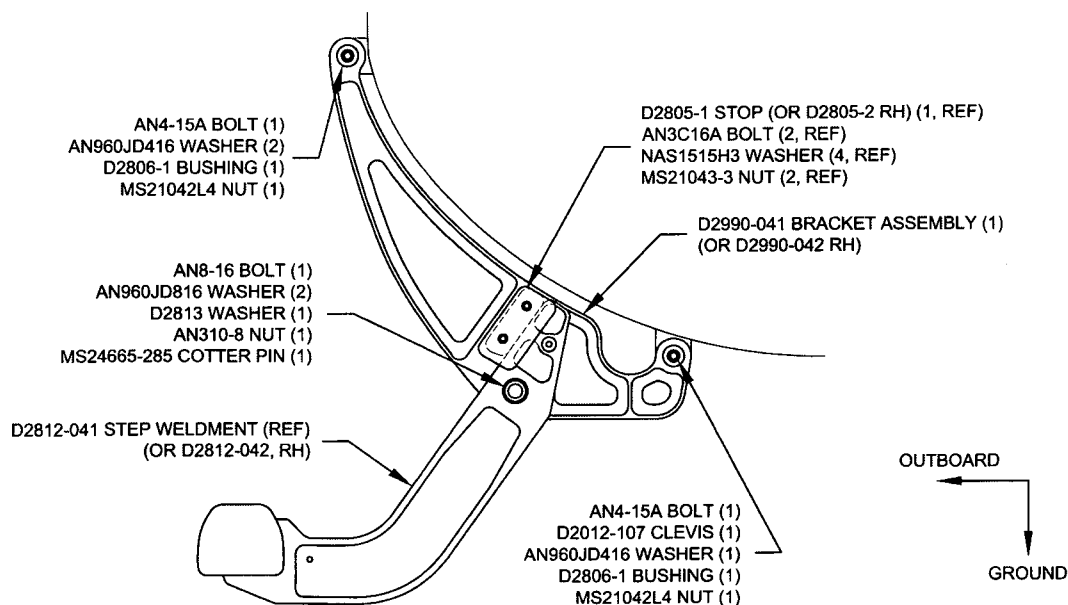
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-011/-012 Heli-Access-Step™ Installation

**FIGURE 4 – STA 84.29 for D412-630-011/-012 Heli-Access-Step™ Installation
(View rotated 90° CW)**



**FIGURE 5 – STA 129.00 for D412-630-011/-012 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: L
Date: 07.09.30

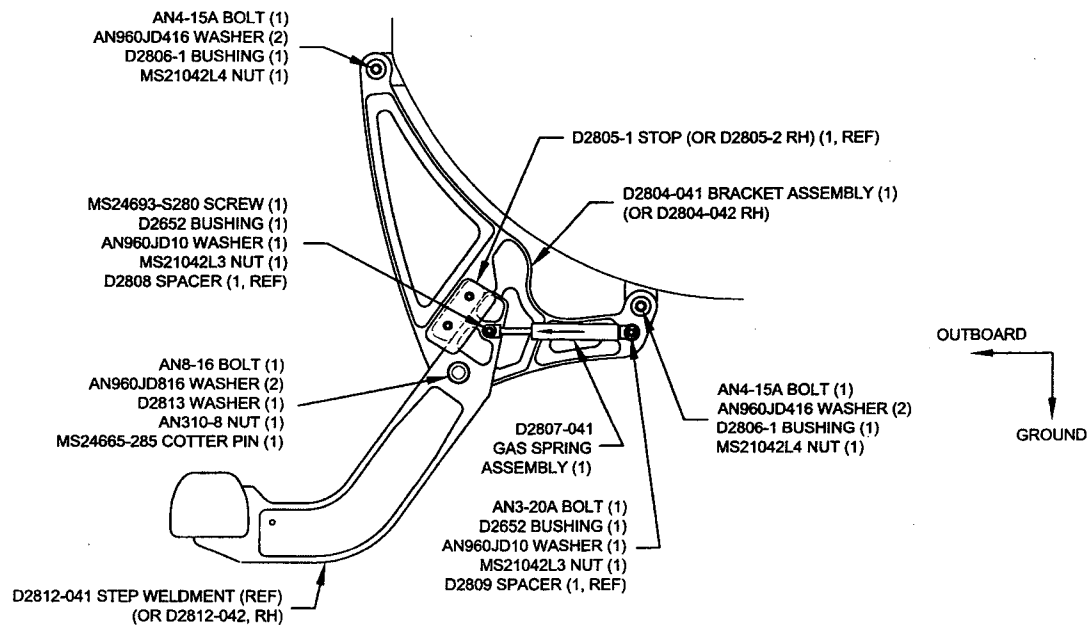


FIGURE 6 – STA 155.06 for D412-630-011/-012 Heli-Access-Step™ Installation (View rotated 90° CW)

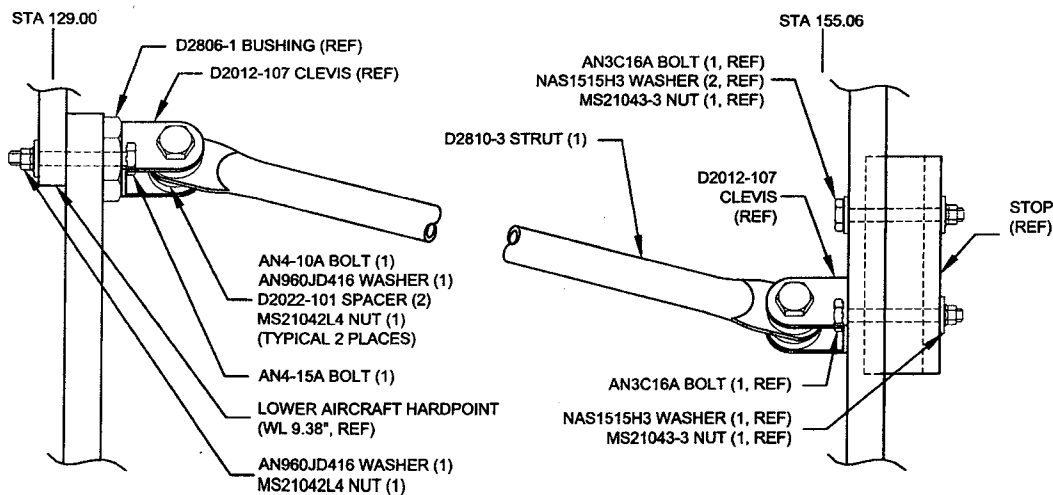
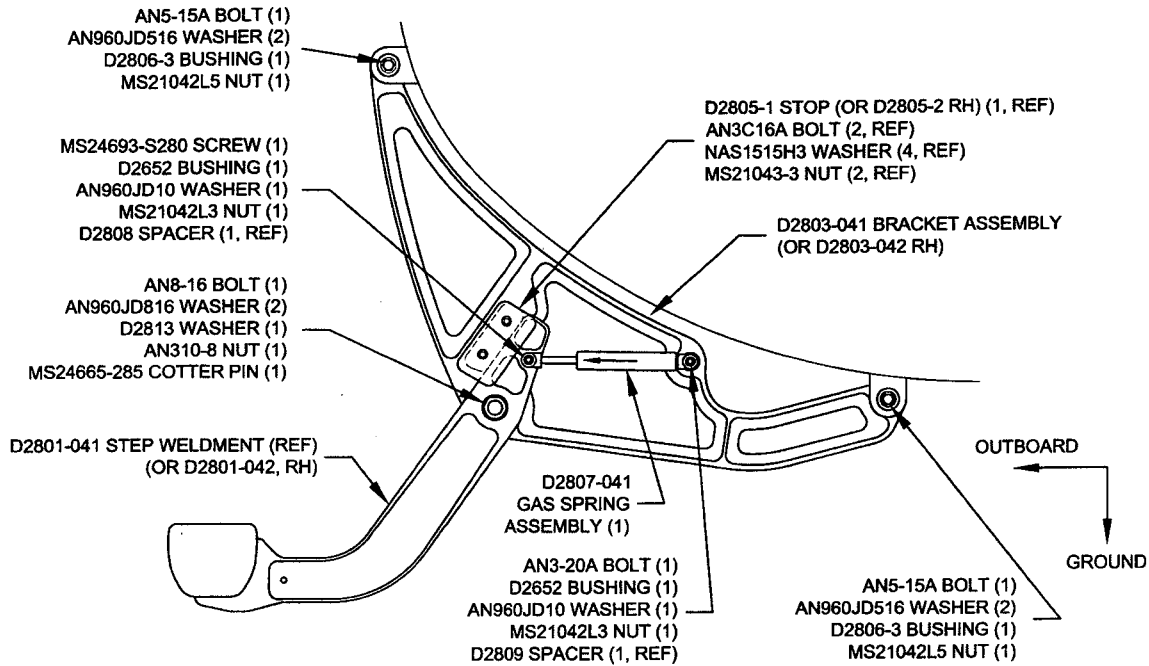
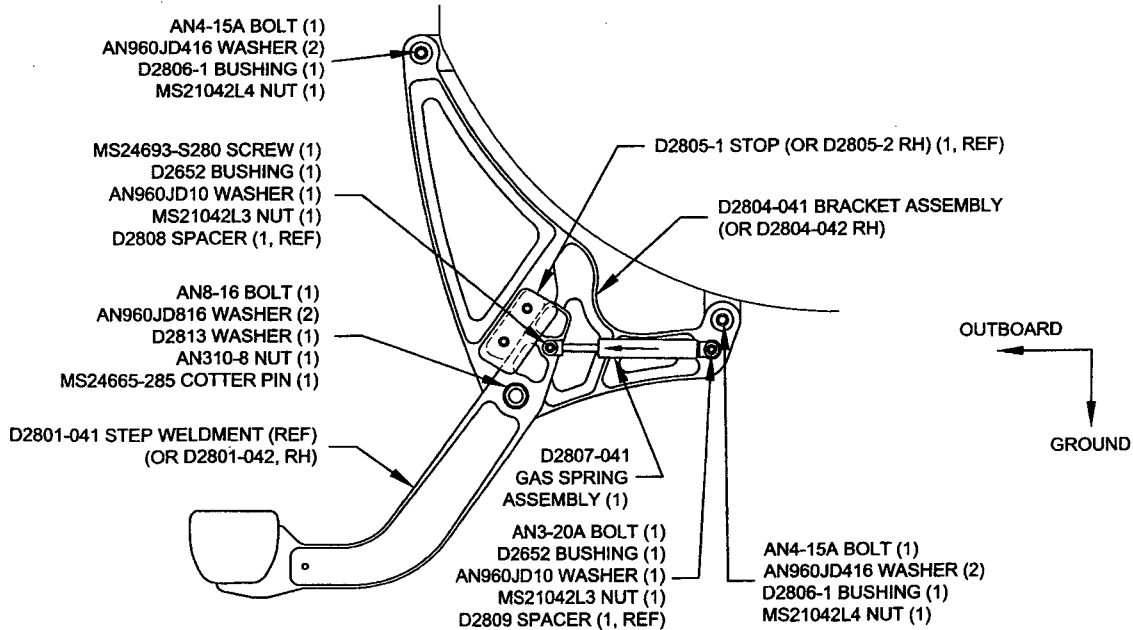


FIGURE 7 – Strut Detail for D412-630-011/-012 Heli-Access-Step™ Installation (NOT TO SCALE)

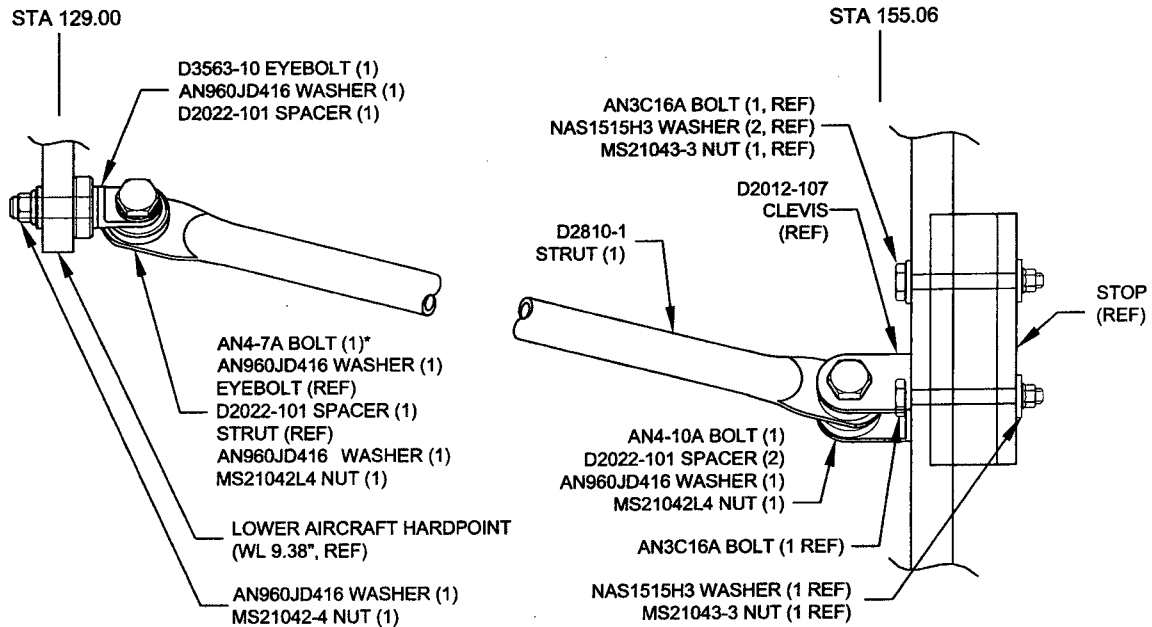
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Date: 07.09.30

D412-630-013/-014 Heli-Access-Step™ Installation**FIGURE 8 – STA 84.29 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 9 – STA 155.06 for D412-630-013/-014 Heli-Access-Step™ Installation
(View rotated 90° CW)**

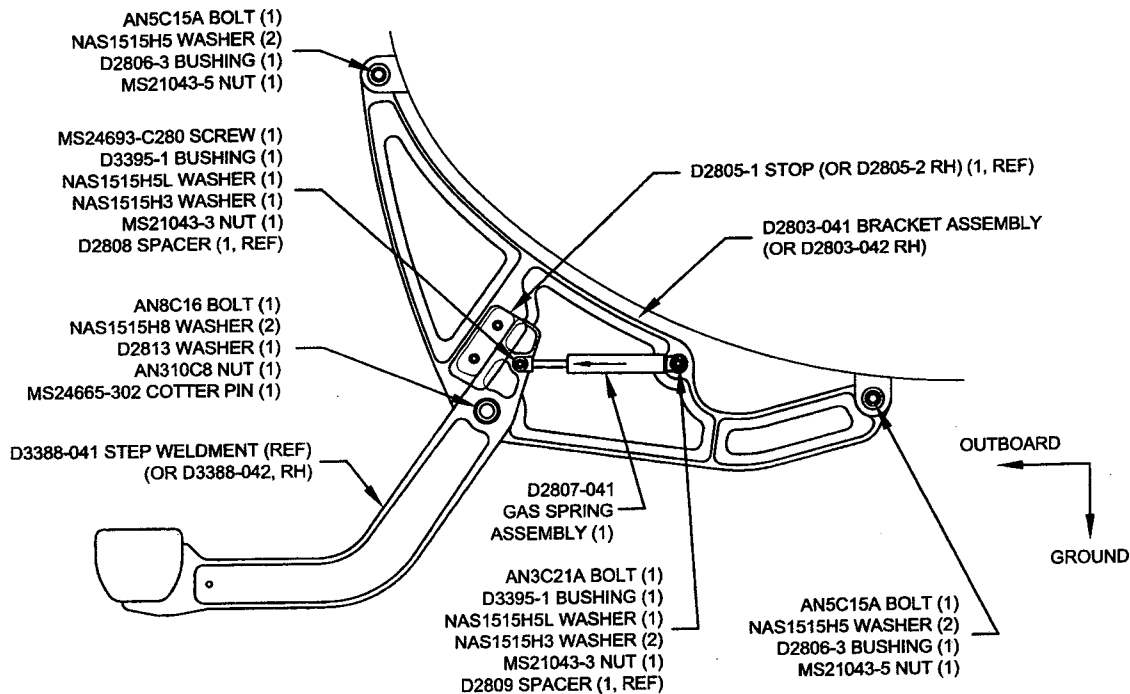
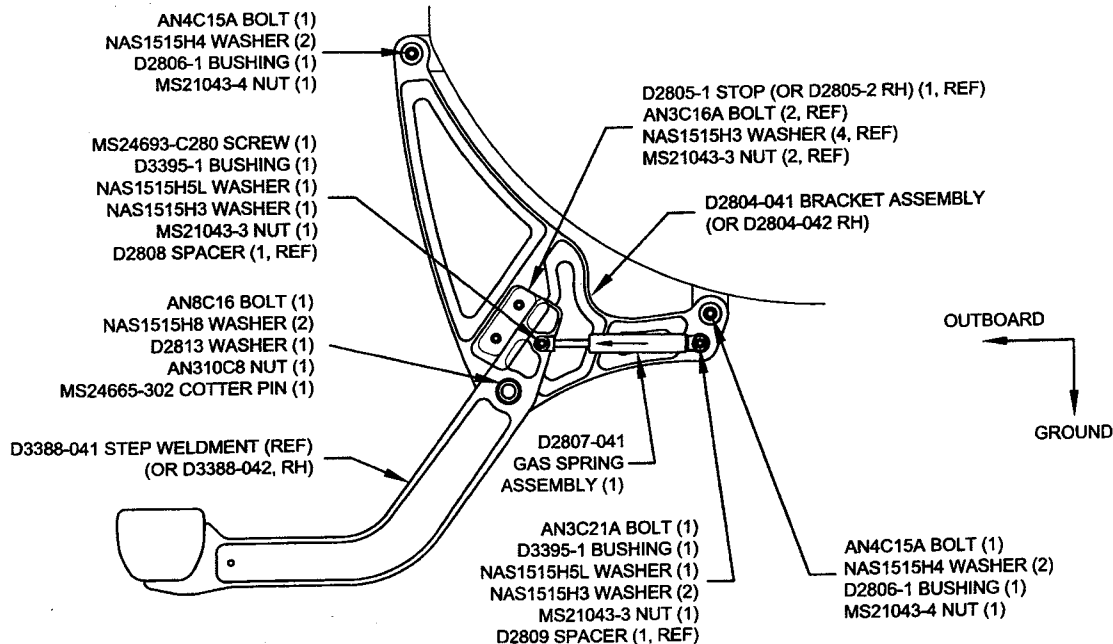
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Revision: L
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* IF ADJUSTMENT OF THE STRUT IS REQUIRED TO AVOID OTHER HARDWARE ON THE AIRCRAFT, IT IS ACCEPTABLE TO USE LONGER AN4 BOLTS AND ADDITIONAL WASHERS AS REQUIRED TO ADJUST THE ATTACHMENT OF THE D2810-1 STRUT TO THE EYEBOLT.

FIGURE 10 – Strut Detail for D412-630-013/-014 Heli-Access-Step™ Installation
(NOT TO SCALE)

D412-630-023/-024 Heli-Access-Step™ Installation**FIGURE 11 – STA 84.29 for D412-630-023/-024 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 12 – STA 155.06 for D412-630-023/-024 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Date: 07.09.30

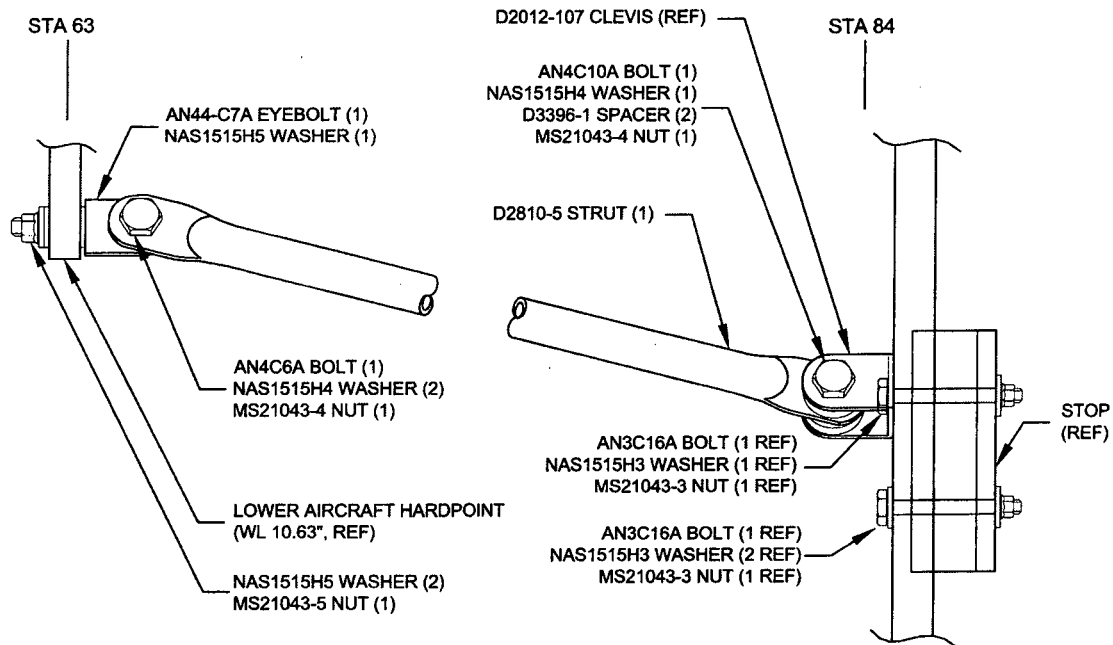
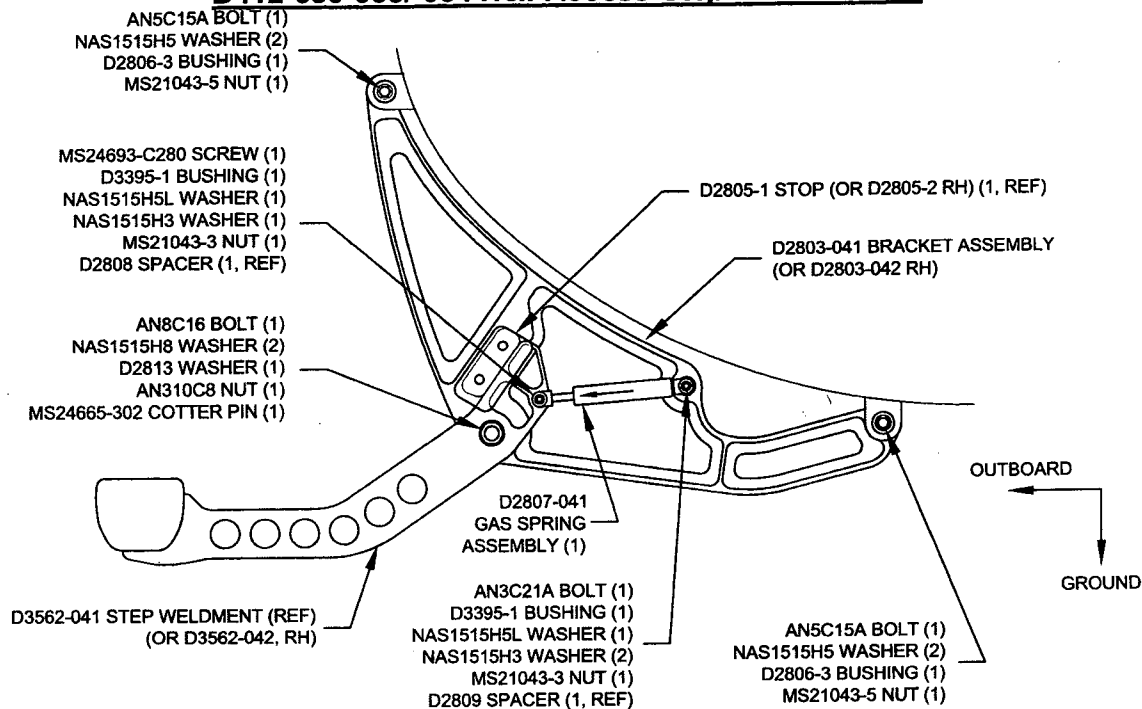
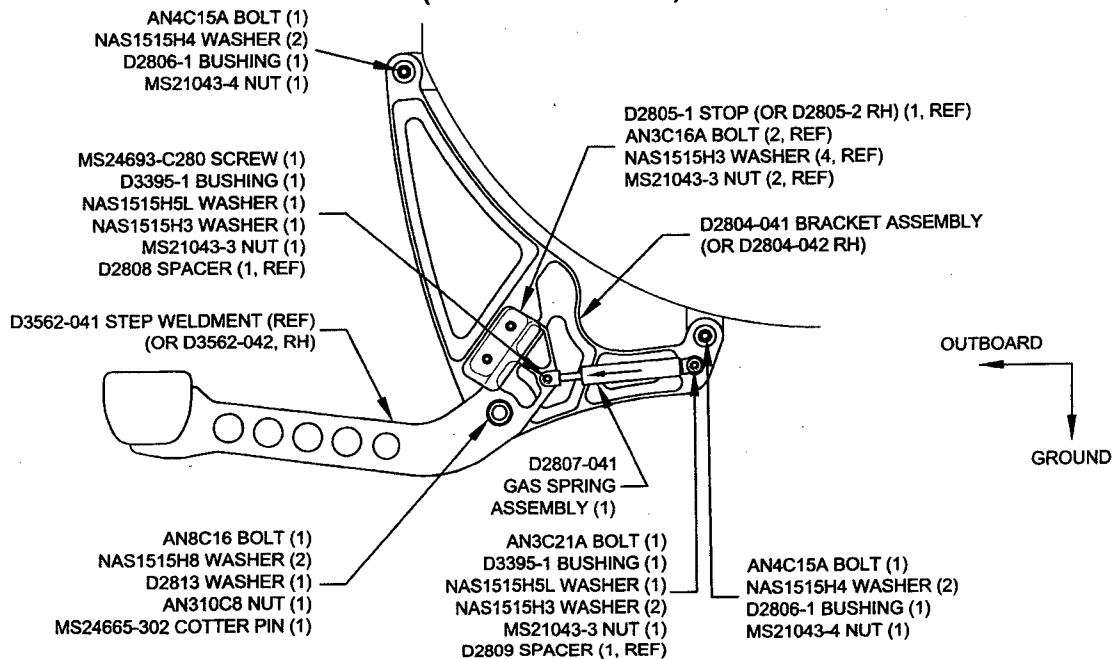


FIGURE 13 – Strut Detail for D412-630-023/024 *Heli-Access-Step™* Installation
(NOT TO SCALE)

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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